

Work Order ID 50180



Page 1

July 10, 2009 8:55:49 AM

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 7/14/09 Start Qty: 1.00



Cust Item ID:

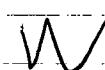
Required Date: 7/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2512	Rev E								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut 3/4" x 3/4" square tubing as per Dwg D2512-2-Cut (4) D2236 From D3166-3 Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305 5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

SAD 09-07-14 Qty 1
84 09/07/16 ix

609.07.20

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Item ID: D2512

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Item Name: Basket Lid 205/350

Start Date: 7/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC6- Inspect dimensions to drawing

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

=> S orlorslo



130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Pressure wash MD 09/07/20 (x1)

0.00

Memo

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat 12- 11ST

COAT: START TIME:

2:00

OVEN TEMPERATURE:

400°

FINISH TIME:

2:30

12ND

COAT: START TIME:

OVEN TEMPERATURE:

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Item ID: D2512

Accept



Setup Start



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Item Name: Basket Lid 205/350

Start Date: 7/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC3- Inspect Part Finish

0.00

=> 50180/21



QC

Memo

0.00

Quality Control

160



Identify as per dwg & Stock Location: _____

0.00

50180/21

Packaging

Memo

0.00

Packaging

170



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/07/23

09-07-23

Picklist Print

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Work Order ID: 50180



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 7/14/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-1RevC		Manufactured	No			100	Each	12.0000	2.0000			

Basket Hinge

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

12

48230

2x

SM 09/07/14

D2327-1RevD



Manufactured

No

Spacer Bushing

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

20

46325

2x

SM 09/07/14

D2506RevF



Manufactured

No

Label Plate

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

5

44275

1

48607

4

1x

SM 09/07/14

Picklist Print

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Work Order ID: 50180



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 7/14/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	35.0000	2.0000			

Mounting Bracket

Warehouse

Location

Main Warehouse

ST 35

46086 2

→ 48428 33

100 Each 6.0000 1.0000

Loc Qty

Loc Code

2x

8409107117

D3166-3RevA1

Manufactured No

Warehouse

Location

Main Warehouse

WA 6

50033 6

Loc Qty

Loc Code

48428 → 1 → 1 SAD 09-07-14 ①

Basket Hoop

Picklist Print

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Work Order ID: 50180



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 7/14/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased		No		100	sf	719.6696	18.0000			

Expanded Metal Flat SS

Warehouse

Location

Main Warehouse

MAT	719.6696	
108152	90	
110134	6.7	
110292	14.4	
110629	14.41	
110861	21.18	
110992	0.58	
111444	17.79	
111630	35.15	
111956	34.36	
112147	485.0996	

Loc Qty

Loc Code

M304TS0.750W.065

Purchased

No

100 f

354.0541 45.8741

2.00
16.00

SAD 09-07-14

304 SQ Tube .75x.75x.065W

Warehouse

Location

Main Warehouse

MAT	354.0541	
110969	3.29	
111148	15.96	
111331	1.96	
111432	0.44	
111885	20.14	
112051	312.2641	

Loc Qty

Loc Code

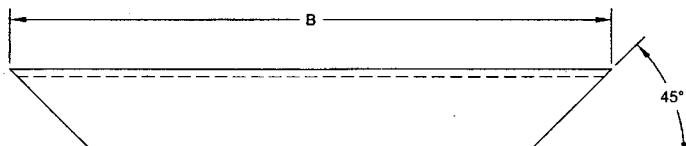
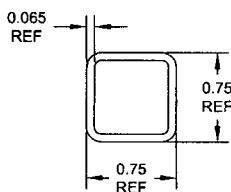
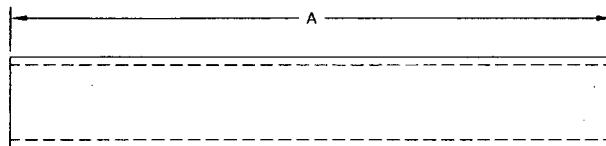
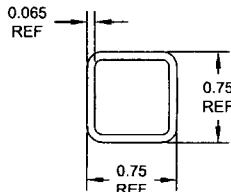
July 10, 2009 8:55:49 AM

Shop Packet Print

Page 3

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	25.50		RIB
D2512-3	2	95.30		RIB
D2512-5	6	30.84		RIB
D2512-7	3	30.63		RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET


D2512-1/-3/-5/-7 NOTES:

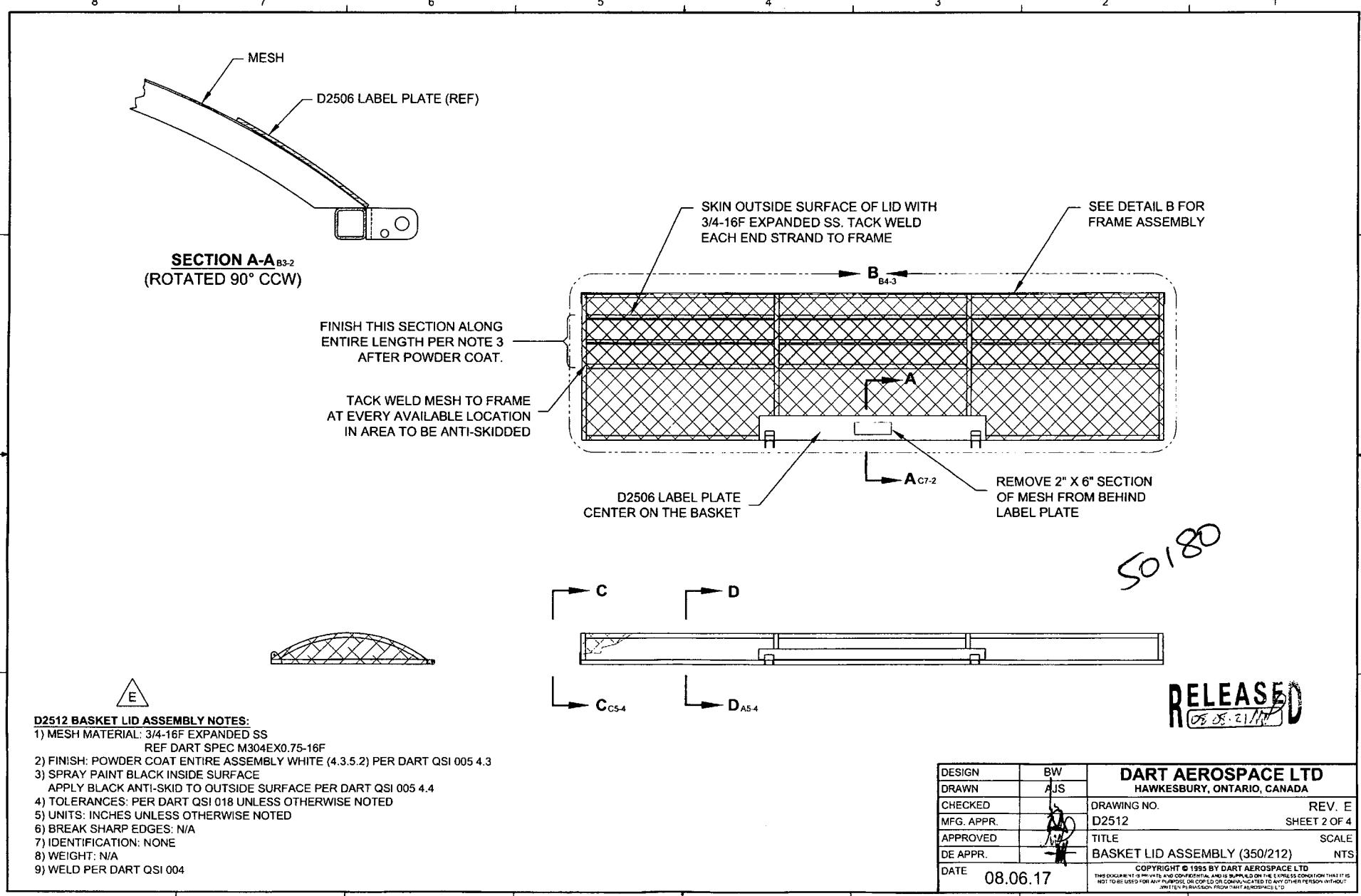
- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

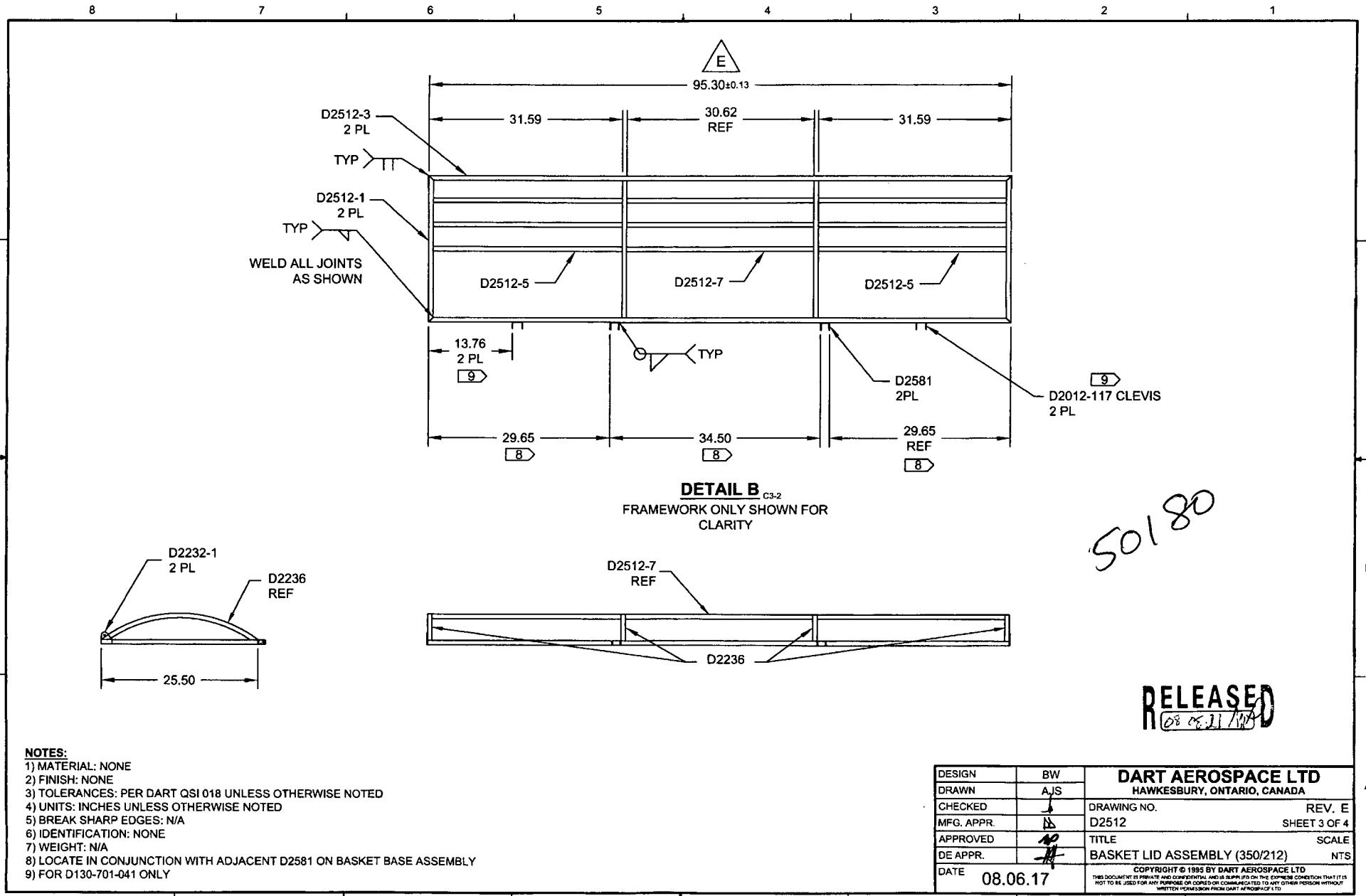
WLO
S0180

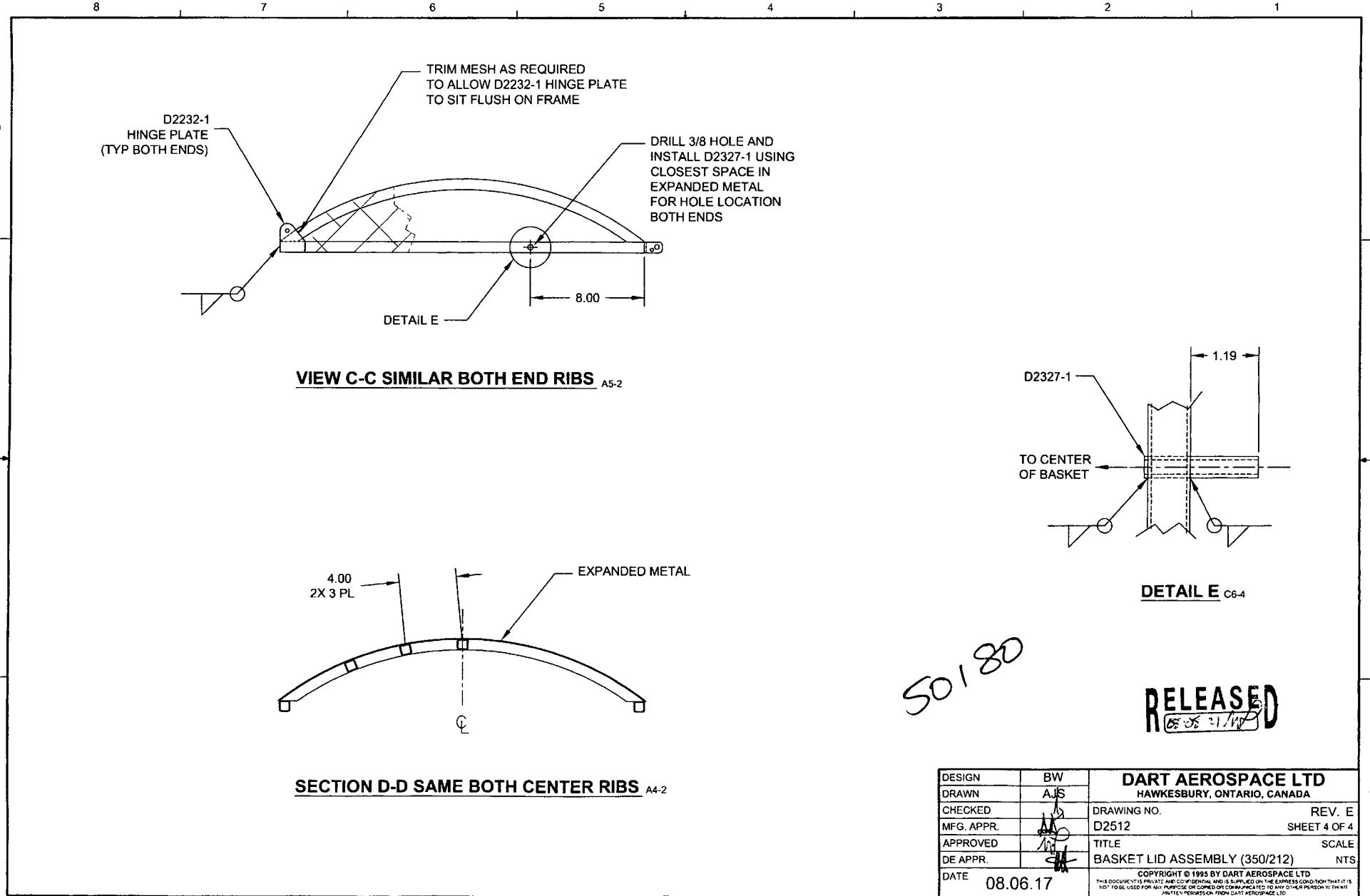
RELEASED
08.06.17

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3. ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	REV. E	
CHECKED		DRAWING NO.	
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE THAN THAT FOR WHICH IT WAS PROVIDED. THE INFORMATION CONTAINED HEREIN IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE COPIED, REPRODUCED, OR DISCLOSED, IN WHOLE OR IN PART, TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	







50, 80

RELEASED
05-05-2014

DESIGN	BW	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. E	
MFG. APPR.		D2512	SHEET 4 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		BASKET LID ASSEMBLY (350/212) NTS		
DATE	08.06.17			

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